

Work Order ID 52438

September 23, 2009 3:02:03 PM



Page 1

Item ID: PB67-43001-51

Accept



Setup Start



Revision ID: *B1 C per EN 09-678*

Item Name: Long T-Handle Assembly

Stop



Start Date: 09/25/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/14/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *09-09-23* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001	Rev B1

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- drill #40 hole in center of -91 before welding -93 caps, to let air out
☐
 2- weld -93 to -91 as per dwg ☐ 3- grind weld flush ☐ 4- assemble -87 under the pilot hole in -91 and weld as per dwg

Cpl 09 10 01

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ S on 10/02

(+2)

f

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10

09.10.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: PB67-43001-51

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Setup Start



Revision ID: B1

Item Name: Long T-Handle Assembly

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Start Date: 09/25/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/14/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

1- line drill -89 and -87 using existing pilot hole of -87 as per dwg 2- install spring pin

CP 09 10 01

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2 Sorkola

2 4

150



Powdercoat

Powder Coating

Green Sandtex (Ref 4.3.5.8) per QSI005 4.3

M 18144

Memo

0.00

0.00

START TIME:

9:00

OVEN TEMPERATURE:

320 FINISH TIME:

9:30

BR 09-10-7

2.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Setup Start



Revision ID: B1

Stop



Item Name: Long T-Handle Assembly

Start Date: 09/25/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/14/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

⇒ 09/10/01

XL

Quality Control

170

Identify as per dwg & Stock Location: Store

0.00



Packaging

Memo

0.00

9/10/07 2054

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/10/08 HJ

Quality Control

W 9-10-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52438



Parent Item: PB67-43001-51RevB1



Parent Item Name: Long T-Handle Assembly

Start Date: 09/25/2009

Required Date: 10/14/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
240-107 SPRING SLOTTED PIN		Purchased	No			100	Each	296.0000	2.0000			

Cpl 09.10.01

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

296

109274

91

111088

205

PB67-43001-87RevB1 Manufactured No



Tube Arm

PB67-43001-89RevB1 Manufactured No



Clevis

100 Each 0.0000 2.0000



② ✓

*352439 Cpl 09.10.01 **

130 Each 12.0000 2.0000



Cpl 09.10.01

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

12

23986

11

40073

1

② ✓

PB67-43001-91RevB1 Manufactured No



Tube Handle

100 Each 11.0000 2.0000



Cpl 09.10.01

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

11

41519

11

2 Cpl 09.10.01 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Parent Item: PB67-43001-51RevB1



Parent Item Name: Long T-Handle Assembly

Start Date: 09/25/2009

Required Date: 10/14/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-93RevB1		Manufactured	No			130	Each	30.0000	4.0000			



Tube End Cap



Pl 09.10.01

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

30

40074

2

41520

28

(4) Pl 09.10.01 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

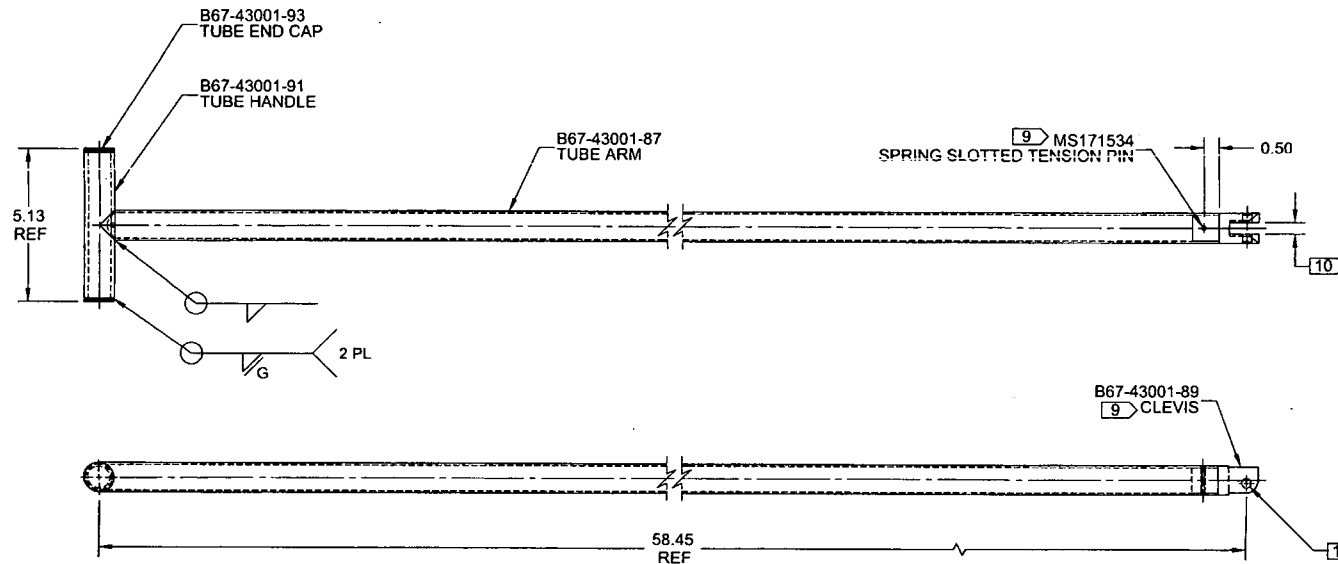
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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ITEM	QTY -19	P/N	DESCRIPTION
1	X	B67-43001-51	LONG T-HANDLE ASSY
3	1	B67-43001-87	TUBE ARM
4	1	B67-43001-89	CLEVIS
5	1	B67-43001-91	TUBE HANDLE
6	2	B67-43001-93	TUBE END CAP
8	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)



B67-43001-51 LONG T-HANDLE ASSY

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.35 lbs
- 8) WELDING: PER QSI 004
- 9) PRIOR TO POWDER COAT, ALIGN B67-43001-89 ON B67-43001-87 AS SHOWN AND DRILL A $\varnothing 0.129$ HOLE THROUGH BOTH PARTS AND FASTEN B67-43001-89 TO B67-43001-87 USING MS171534 SPRING SLOTTED PIN
- 10) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN			
CHECKED	ASS		
MFG. APPR.	AD		
APPROVED	AW		
DE APPR.	N/A		
DATE	09.06.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-51** REV. C
SHEET 1 OF 1

TITLE **LONG T-HANDLE ASSY** SCALE NTS

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